

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007087**Date Inspected:** 25-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Larry Viars was present during the times noted above for observations relative to the work being performed.

Bay 3-

This QA Inspector observed the following work in progress: SMAW welding of weld joint 001, 002, 003 and 004 located on OBG Bottom Plate 202-016. ZPMC welder was identified as 203204. ZPMC QC is identified as Xu Xian Ping. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2112-FCM.

FCAW welding of weld joint 003 located on OBG Floor Beam FB003-179. ZPMC welder was identified as 044790. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2132-3.

FCAW welding of weld joint 027 located on OBG Floor Beam FB011-034. ZPMC welder was identified as 208035. ZPMC QC is identified as Chen Xi. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2133.

Bay 11-

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The

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member was identified as Tower Skin Plates NSD1-FCSA4- 1 A/C and SSD1-FAS4- 1AE. The weld identification numbers are as follows: NSD1-FCSA4-1 A/C- 58B, 61B and SSD1-FASA4- 1 A/E-7B.

This QA inspector performed Ultrasonic Testing (UT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member was identified as WD1-A467-38M-2 . The weld identification number was identified as 001.

This QA Inspector observed the following work in progress: SMAW welding of weld joint 4A located on West Tower Lift 4 Skin Plate WSD1-FASA4-2 A/E. ZPMC welder was identified as 041271. ZPMC QC is identified as Li Ming. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-4211-B-U3b-2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general between QA and QC occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134 8257 0045, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
